

Work Order ID 146093

146093

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Thursday, May 12, 2016 11:37:02 AM

Item ID: D4577-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rear Access Panel
 Start Date: 5/5/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 5/9/2016 Req'd Qty: 4.00 *4* Customer:

Reference:

Approvals: Process Plan: DAS 13 Date: MAY 12 2016 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4577	C								
100	FLOW WATER JET	0.04							
100									
Waterjet	Memo	0.40							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>S</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.08							
Quality Control									

JUL 12 2016

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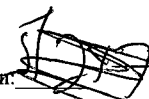
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 Required Date: 5/9/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.56				(5)			2016/07/13 BEB
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.04				(5)			DMS 38 9-89 JUL 13 2016
190 *190* Packaging Packaging	Identify as per dwg & Stock Location:  Memo WA003	0.00 0.04				aj S	PC		JUL 13 2016

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Item ID: D4577-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Access Panel

Start Date: 5/5/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00						DAS 21 9-89	JUL 14 2016
200									
QC	Memo	0.40							
Quality Control									

DAS
21
9-89 JUL 14 2016

Picklist Print

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Parent Item: D4577-1

D4577-1

Parent Item Name: Rear Access Panel

Start Date: 5/5/2016

Required Date: 5/9/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B
12.04.25 AS PER DWG REV.B DD VERF:EC IPP REV:C 15.01.15
AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	74.8200	0.84	3.536842			

M6061T6S 125

6061-T6 .125 Sheet

**

PK 2016/07/11

Location

Loc Qty

Loc Code

MAT020

74.81995

m130745

0.79995

m134067

0.355

m134217

41.665

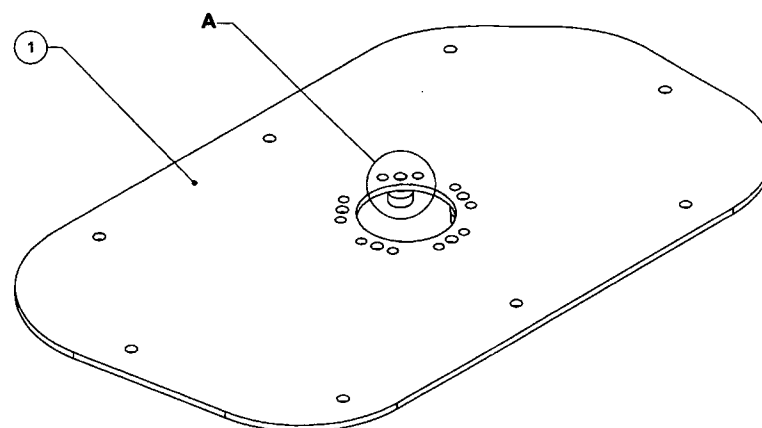
m134696

32

M134982

3.3

ITEM	QTY	P/N	DESCRIPTION
	X	D4577-041	FWD ACCESS PANEL ASSEMBLY
1	1	D4577-5	FWD ACCESS PANEL
2	10	MS20426AD3-5	RIVET, SOLID, CSK
3	5	NAS1474R3	ANCHOR NUT (OR NAS1474A3 OR NAS1474S3 OR NAS1474F3)



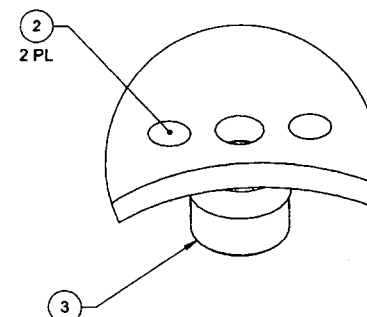
D4577-041 FWD ACCESS PANEL ASSEMBLY

PHOTO COPY
 IDENTICAL
 ENGINEERING
 ORIGINAL NOTED COPY
 146093 MJS
 160509

RELEASED

2015 JAN 15

14-66



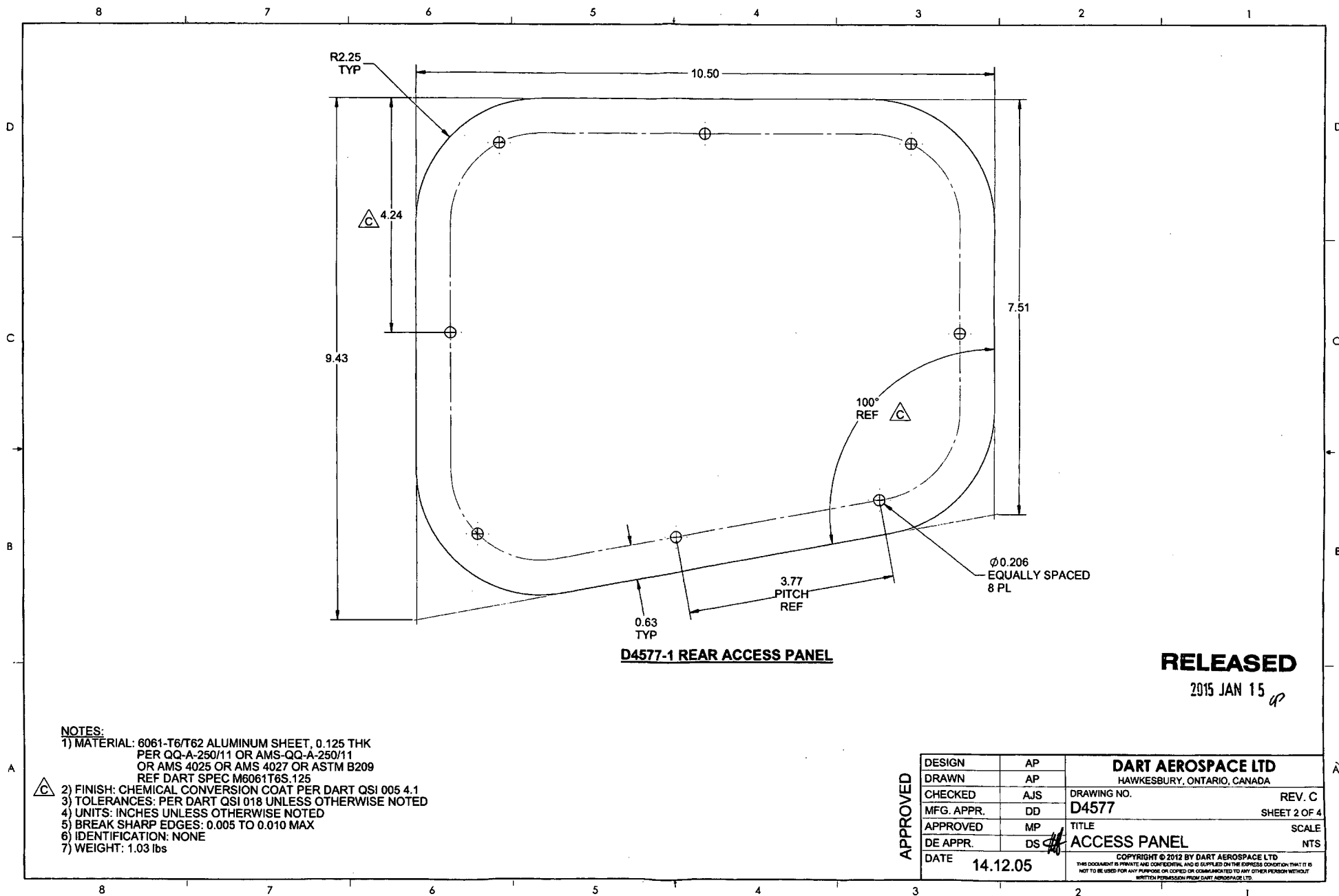
DETAIL A
 SCALE 4X
 5 PL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.08 lbs

C	REMOVED POWDER COAT FINISH ON ALL PARTS (SHT 1-3); FORMAT UPDATED; REVISED WEIGHT (SHT 1); VARIOUS MINOR DIMENSIONAL CHANGES, ALL PARTS NOW FULLY DIMENSIONED; REMOVED UNNECESSARY VIEWS	AP	14.12.05
B	REMOVE D4001-1; ADD NAS1474R3, ZN C2-1, MODIFY -5 FOR HARDWARE; ZN C5-4, INCREASE THICKNESS OF -1/-3/-5; IS 0.125", WAS 0.063". MODIFY DIMS OF -1/-3/-5.	DC	12.03.30
A	NEW ISSUE	DC	12.01.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4577	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	ACCESS PANEL	NTS
DATE	14.12.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.03 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4577	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	ACCESS PANEL	NTS
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